

Work Order ID 60620

Thursday, July 15, 2010 10:27:30 AM



Item ID: D4030-041

Accept

Setup Start

Stop

Revision ID:

Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-7-15 Tooling:

Date:

Run Start

Stop

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	0.00							
D4030	B U/R 10-07-15	0.00							
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

10-7-15 ①

110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

6/30/07/20

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, July 15, 2010 10:27:34 AM

Work Order ID: 60620



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Oty: 1.00

Start Qty: 1.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Thursday, July 15, 2010 10:27:34 AM

Work Order ID: 60620**Parent Item:** D4030-041**Parent Item Name:** Long Basket Assembly (350)**Start Date:** 7/15/2010**Required Date:** 7/22/2010

D3914-041



Manufactured No

100 Each

0.0000

Start Qty: 1.00

1

B60625 (R)

Required Qty: 1.00

1

E60/07/27

Long Basket Lid Assembly (350)

D3917-3



Manufactured No

100 Each

25.0000

6

6

Washer

Location Loc Qty Loc Code

ST095 12

60298 12

ST096 13

57144 1

58892 12

100 Each

22.0000

2

2

2

E61

D3953-3



Manufactured No

Location Loc Qty Loc Code

ST102 22

58894 2

59437 20

100 Each

22.0000

2

2

2

59437

D3953-7



Manufactured No

Location Loc Qty Loc Code

ST103 22

58893 2

59438 20

100 Each

22.0000

2

2

2

59438

Spring Spacer

Shop Packet Print

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 3

Thursday, July 15, 2010 10:27:34 AM

Work Order ID: 60620**Parent Item:** D4030-041**Parent Item Name:** Long Basket Assembly (350)**Start Date:** 7/15/2010**Required Date:** 7/22/2010**Start Qty:** 1.00**Required Qty:** 1.00

D3953-9

Manufactured No

100 Each

34.0000

2

2



Gas Spring Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST101	14	
53642	2	
59147	12	
ST103	20	
60008	20	

D3953-17

Manufactured No

100 Each

28.0000

2

2



Gas Spring Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST101	28	
57143	1	
59197	27	

D3953-19

Manufactured No

100 Each

16.0000

1

1



Gas Spring Bracket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST101	2	
57607	2	
ST103	14	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, July 15, 2010 10:27:34 AM

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Work Order ID: 60620



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3953-21



Gas Spring Bracket

Manufactured

No

100

Each

24.0000



1

C

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ENG	5	
56407	5	
ST102	19	
57145	2	
59214	17	

D3969-3



Spring (Basket Lid)

Manufactured

No

100

Each

9.0000



1

C

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST	9	
56386	1	
58986	8	

AN3-14A



Bolt

Purchased

No

100

Each

122.0000



4

C 4/2/23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST351	122	
114330	22	
114941	50	
115108	50	

114330

C 4/2/23

Thursday, July 15, 2010 10:27:34 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, July 15, 2010 10:27:34 AM

Page 5

Work Order ID: 60620



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN3-16A



Purchased

No

100

Each

126.0000

2

2

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST352	126	
113845	6	
114523	20	
114752	100	

113845

AN5-17A



Purchased

No

100

Each

119.0000

4

4

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST339	119	
114330	73	
114784	46	

114330

AN4-12



Purchased

No

100

Each

52.0000

3

3

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	52	
114292	2	
114784	50	

114784

AN310-4



Purchased

No

100

Each

53.0000

3

3

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST324	53	
114716	3	
115107	50	

115107

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, July 15, 2010 10:27:34 AM

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Work Order ID: 60620



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN310C4



Purchased

No

100

Each

50.0000

12

2

✓

✓

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST349	50	
-------	----	--

114306	50	
--------	----	--

MS21042L3



Purchased

No

100

Each

2,684.000

16

6

✓

✓

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST300	2684	
-------	------	--

112385	4	
--------	---	--

114523	204	
--------	-----	--

114718	476	
--------	-----	--

114784	2000	
--------	------	--

MS21042L5



Purchased

No

100

Each

893.0000

4

4

✓

✓

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST139	393	
-------	-----	--

114813	393	
--------	-----	--

ST300	500	
-------	-----	--

115156	500	
--------	-----	--

MS24665-151



Purchased

No

100

Each

634.0000

3

3

✓

✓

Cotter Pin

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST309	634	
-------	-----	--

17566	634	
-------	-----	--

17566

W/O:		WORK ORDER CHANGES					
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Thursday, July 15, 2010 10:27:34 AM

Page 7

Work Order ID: 60620



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

MS24665-300



Purchased

No

100

Each

60.0000

2

2



Cotter Pin

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST309

60

110123

105279

2

110123

58

NAS1149F0432P



Purchased

No

100

Each

420.0000

6



Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST275

420

114718

112940

92

114405

1

114576

10

114718

317

NAS1149F0563P



Purchased

No

100

Each

212.0000

4



Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST275

12

108471

ST298

12

114576

200

200

NAS1149F0332P



Purchased

No

100

Each

691.0000

8



WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST275

691

18057

18057

691



Thursday, July 15, 2010 10:27:35 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 15, 2010 10:27:35 AM

Page 8

Work Order ID: 60620



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

NAS1149C0432R



Washer

Purchased

No

100

Each

730.0000

2

2

Start Date: 7/15/2010

Start Qty: 1.00

Required Date: 7/22/2010

Required Qty: 1.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	730	
114292	140	
114742	590	

114292

Rappas

Thursday, July 15, 2010 10:27:35 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
	X		D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6	1		D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17	2		AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20	2		AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
29	8	8	NAS1149F0332P	WASHER
30	2	2	NAS1149C0432R	WASHER
31	2	2	NAS1149C0432R	WASHER

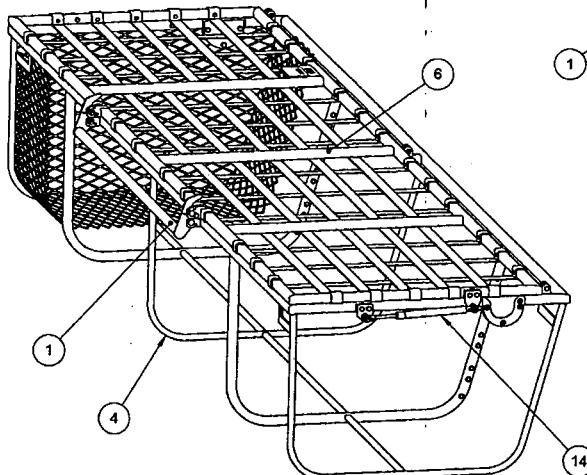
10.07.15

8 7 6 5 4 3 2 1

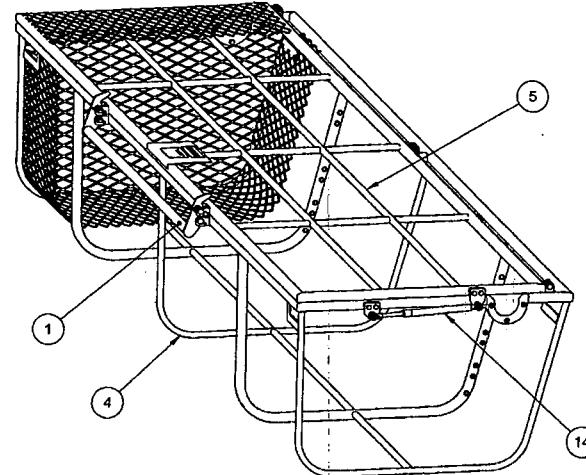
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

5
STOP
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *00620*
B910-7-15



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

UNDER REVIEW
PROCEDED
10.07.15
-043 MISSING QTY
FOR 170415 SO. 31
RELEASED
R 2010-04-14
10P

B	ANS-21A BOLT WAS AN5-19A: BOM & (D3-3)		JPH	10.04.06
A	NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>12</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>RS</i>	D4030	SHEET 1 OF 3	
APPROVED	<i>ANP</i>	TITLE	SCALE	
DE APPR.	<i>ANP</i>	LONG BASKET ASSY (350)	NTS	
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

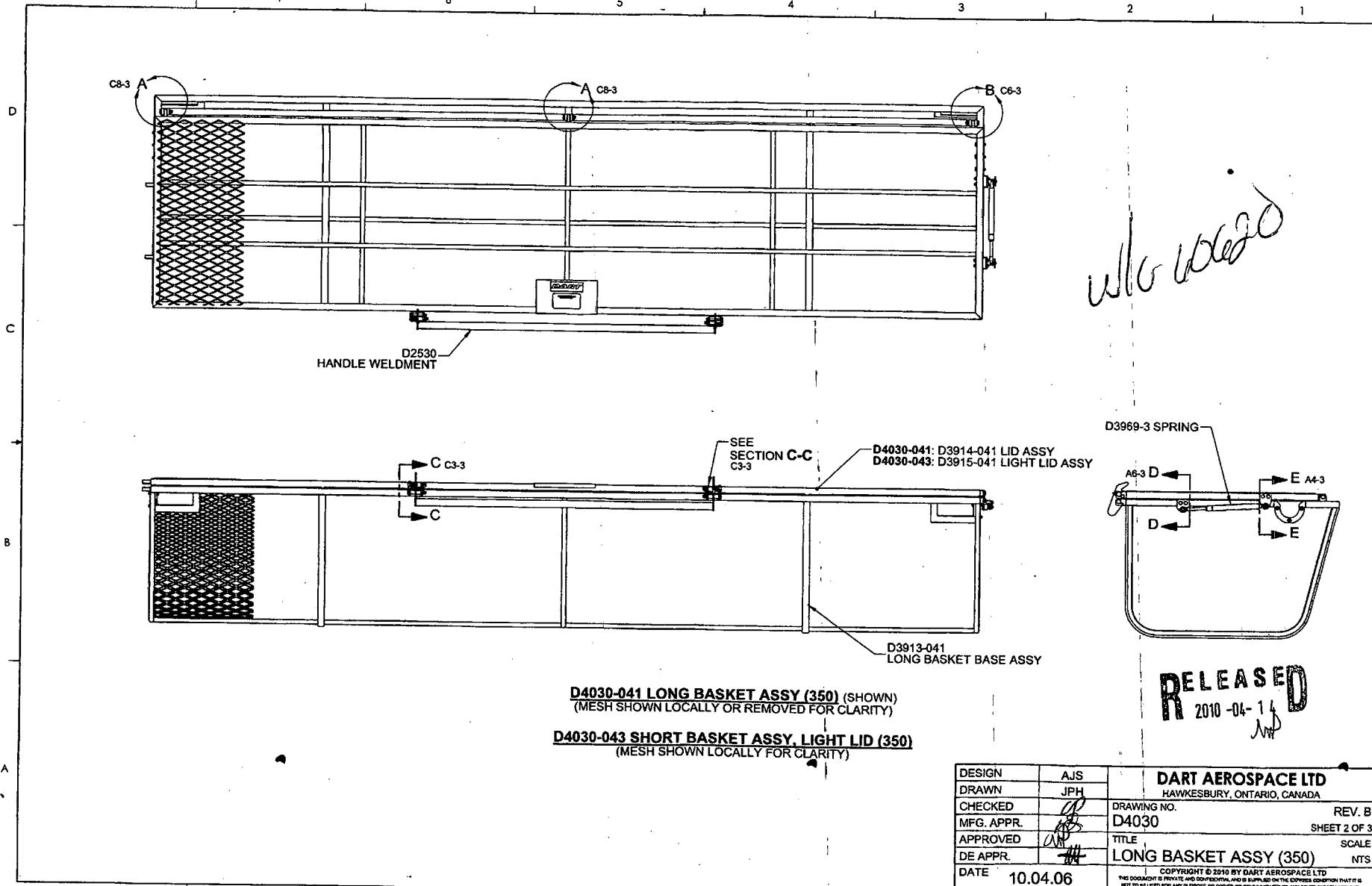
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

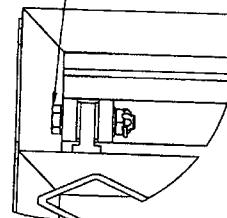
3

2

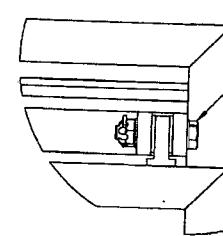
1

D

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



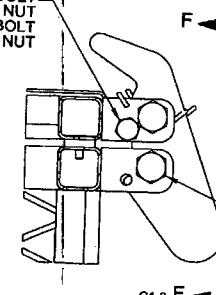
DETAIL A D8-2
D5-2



DETAIL B D3-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT

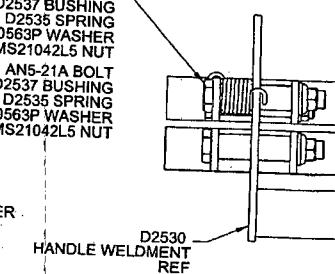
AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

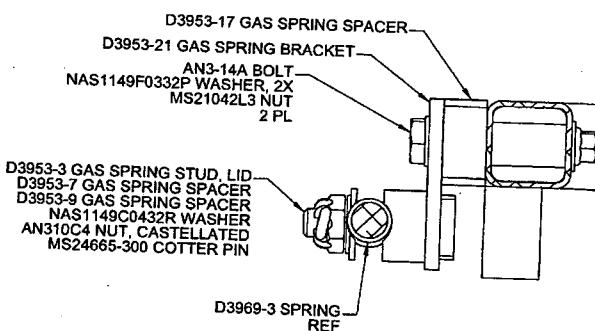
△ D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



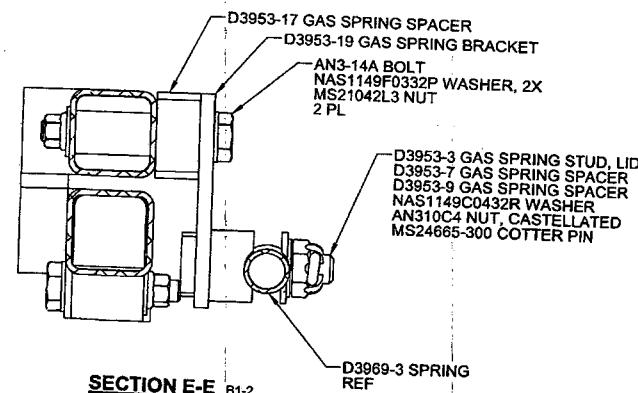
VIEW F-F C3-3

W6 46626

B



SECTION D-D B2-2



SECTION E-E B1-2

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>OF</i>	DRAWING NO.
MFG. APPR.	<i>RE</i>	REV. B
APPROVED	<i>RE</i>	SHEET 3 OF 3
DE APPR.	<i>RE</i>	TITLE
DATE	10.04.06	SCALE
		LONG BASKET ASSY (350) NTS

RELEASED
2010-04-14

NP

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries